

Date: Friday, 8/3/2007 1:59:34 PM  
User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ACCESS PANEL ASSEMBLY
Job Number : 33830	
Estimate Number : 12546	
P.O. Number : <i>N/A</i>	Part Number : D3256041
This Issue : 8/3/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3256 REV B
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 33475	Material : <i>N/A</i>
Written By : <i>JLM 07-08-03</i>	Due Date : 8/10/2007
Checked & Approved By : _____	Qty: <i>2</i> Um: Each
Comment : Est Rev:A New Issue 06-10-03 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S22GA	304/316 .032 Sheet
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Comment: Qty.: 0.9870 sf(s)/Unit Total : 0.9870 sf(s)

*X* 304/316 .032 Sheet

Batch: *M105061 m102159*

*SAD*

*07/08/03*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

*07-08-03* 1-Cut as per Dwg D3256

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

*SAD 07/08/03*

*2*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 07/08/03*

*(2)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*EN*

*07/08/03 (47)*

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE Form using D3256-1T2

*FF 07-08-07*

*1 Panel Returned To  
waterJet 07-08-08 FF*

Date: Friday, 8/3/2007 1:59:34 PM  
User: Jean-Luc Menard

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 33830

Part Number: D3256041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sn 07/08/09 (21)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

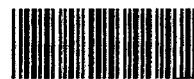
Location: 5240

07/08/09 (1)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/09 (1)

Job Completion

4/07/08-10



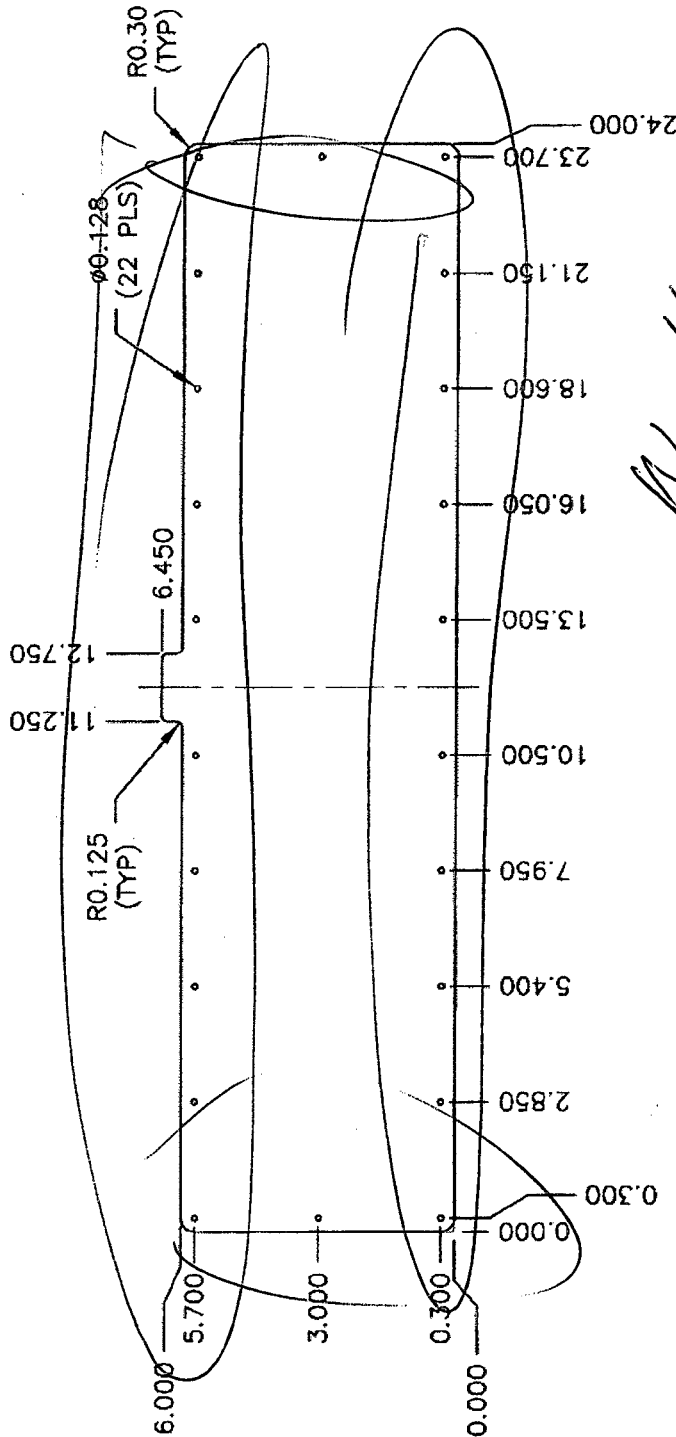
C207/08/09

6.1 D3256-3

BATCH: 30307.



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3256	REV. B SHEET 2 OF 3
DATE 05.06.27		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4



*No Holes  
But formed*

**D3256-1 FLAT PATTERN**

**D3256-1 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

**RELEASED**

05.06.30 *[Signature]*

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**Jean-Luc Menard**

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**From:** Dan Stow [dstow@dartaero.com]  
**Sent:** Friday, August 03, 2007 1:37 PM  
**To:** 'Marc Bellavance'; Dale Trepanier (Dale Trepanier); Holly Menard; 'Jean-Luc Menard (E-mail)'  
**Cc:** Bill Beckett (Bill Beckett); Eric Charbonneau; Jason Loader (Jason Loader); 'Mike Petsche'  
**Subject:** Easy Access Kit

Hi Marc,

We have a customer (Edwards and Associates) that is having a problem fitting some of the panels included in the kit. Jason Loader spoke with the sheet metal worker that is installing the kit and they came to the following conclusions.

For the D412-705-015 Drive Shaft Tunnel kit:

For some reason there bolt pattern is slightly different from the standard so we need to send them:

- (1) One times D3256-3 Gasket *Stack*
- (2) One times D3256-041 Access Panel WITHOUT THE GASKET INSTALLED AND WITHOUT ANY HOLES – the panel will still be bent and formed as per dwg

For the D412-705-013 Intake Plenum Kit:

- (1) One times D3245-041 and D3245-042 WITHOUT THE GASKET INSTALLED, WITHOUT THE TWELVE 0.204" HOLES, AND WITHOUT THE EIGHT 0.098" HOLES FOR THE NUTPLATES ALONG THE OUTER EDGE. Other than that it should fully assembled. The Four MS21060-L3KI nutplates and Eight MS20427M3-3 rivets and the required gasket should be placed in a kit bag to send.

JL will have a marked up drawing to avoid any confusion

Dale – please initiate an NCR and supply Holly with the number

Holly – please send the above items no-charge to Edwards and Associates c/o Mike Milhorn and Jason Cochrane  
I'm not sure of the address but the phone number is 1.423.538.5111

Thank You

Dan Stow  
Technical Support  
Dart Aerospace  
Tel: 613.632.5200  
Cell: 613.676.0992  
dstow@dartaero.com

8/3/2007

DART AEROSPACE LTD		Work Order:	33830
Description: Access Panel Assembly		Part Number:	D3256041
Inspection Dwg: D3256 Rev: B		Page 1 of 1	

## FIRST ARTICLE INSPECTION CHECKLIST

<input checked="" type="checkbox"/>	First Article	<input type="checkbox"/>	Prototype
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[illegible]

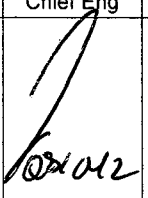
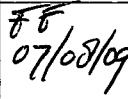



Measured by: <u>SAD</u>	Audited by: <u>En</u>	Prototype Approval: <u>N/A</u>
Date: <u>07/08/03</u>	Date: <u>07/08/03</u>	Date: <u></u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/08/08	#20	one extra D3256-4H1 WAS machined on the water jet. It was made as a backup in case of a mistake.		Return to water jet to be put into stock	 07/08/09	 07/08/08	 07/08/08	 07/08/08

NOTE: Date & initial all entries